

ASAP - *[Signature]*

Dart Aerospace Ltd.

Date: Wednesday, 18/03/2009 2:18:12 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASS'Y
Job Number	: 46560		
Estimate Number	: 10569		
P.O. Number	:	Part Number	: D34437
This Issue	: 18/03/2009 S.O. No. :	Drawing Number	: D3443 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 46145	Material	:
Written By	: <i>[Signature]</i>	Due Date	: 19/03/2009 Qty: <i>20</i> Um: <i>10</i> Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: A 05.11.14 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W120	304 ss round tube .750 x .120w
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*20x*

Comment: Qty.: 0.7875 f(s)/Unit Total: 15.7500 f(s)
AISI 304 SS seamless tubing 0.750" OD x 0.120" wall
(M304TR0750W120)
Batch: *M111097*

M-L 04/03/19

2.0	BRAKE NC	NC BRAKE
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*20x*

Comment: NC BRAKE
1- Form as per Dwg D3443 using DT8117

So 09/03/19

2- Deburr per dwg D3443

M-L 04/03/19

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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*20x*

Comment: SMALL & MEDIUM FAB RESOURCE 1
GRIND RAD PER DWG

M-L 04/03/19

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09/03/19 20
all 0.120" wall

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
1- Mill end to length and drill hole as per dwg D3443

2-Deburr as per dwg D3443

S.A 09/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 18/03/2009 2:18:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 46560

Part Number: D34437

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 09/03/20

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 09/03/23 (20)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

QALC

P 09/3/23 (20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24 JF

Job Completion



MF 09-03-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46560
Description: TUBING		Part Number: D3443-7
Inspection Dwg: D3443 Rev: 8		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.260	+0.000/-0.030	0.254	✓			
Ø 0.750	+/- .010	Ø 0.749	✓			
0.120	+/- .010	0.120	✓			
R 0.51	+/- .030	R 0.51	✓			
Ø 0.438	+0.005/-0.001	0.441	✓			
0.55	+/- .030	0.548	✓			
1.10	+/- .030	1.10	✓			
8.47	+/- .030	8.470	✓			
0.610	+0.015/-0.000	0.617	✓			
0.375	+/- .010	0.375	✓			
Ø 0.125	+0.004/-0.001	Ø 0.127	✓			

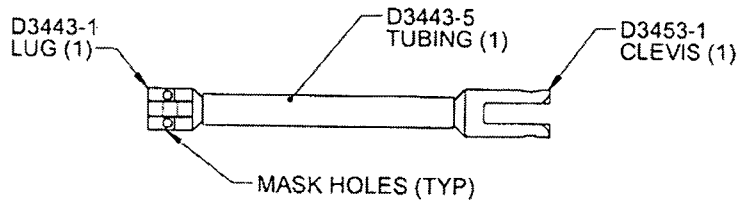
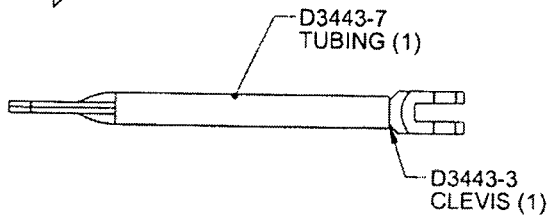
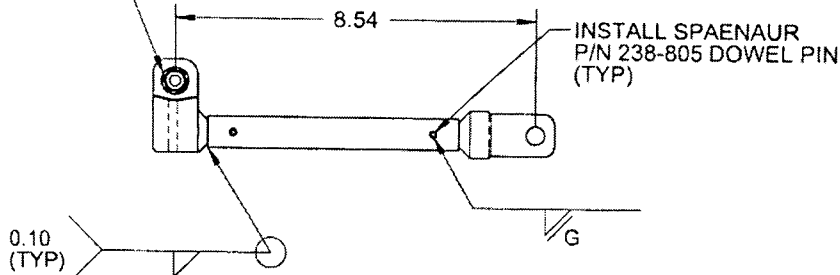
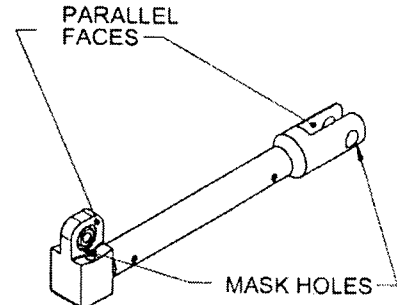
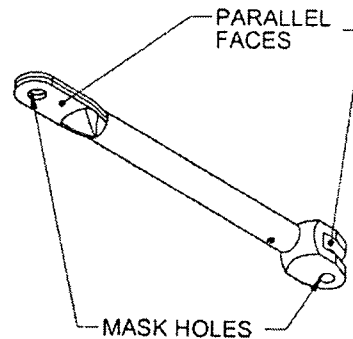
Measured by: L.A	Audited by: J.F	Prototype Approval:	N/A
Date: 09/03/20	Date: 09/03/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE: & $\phi 0.125$ WAS #30	

RELEASED

05.12.04 *[Signature]*PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COATINSTALL SPAENAU P/N 238-805
DOWEL PIN**D3443-041***W/D 46560***D3443-043****NOTES:**

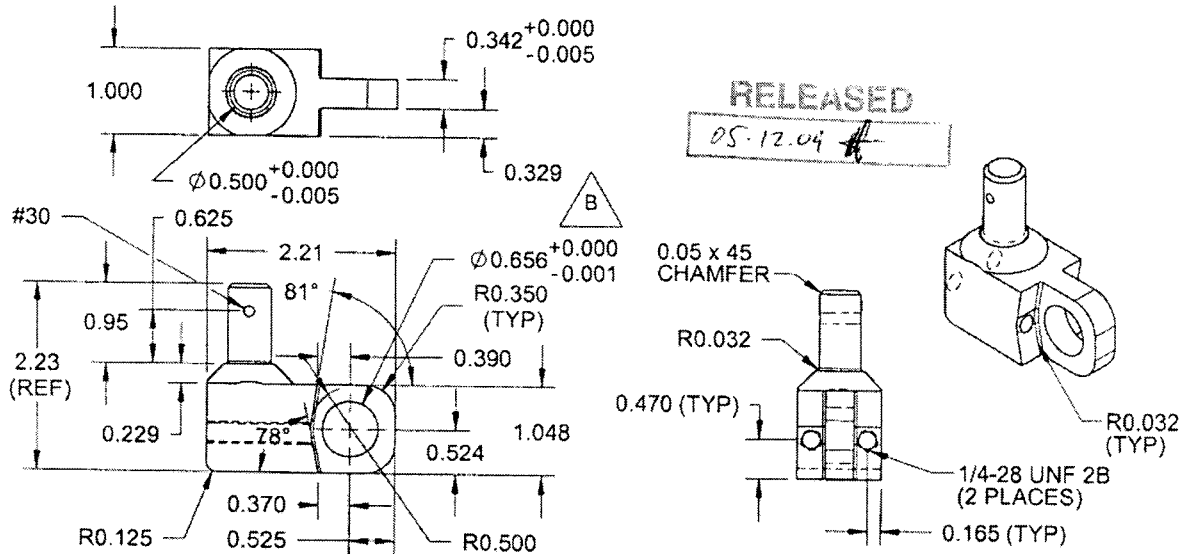
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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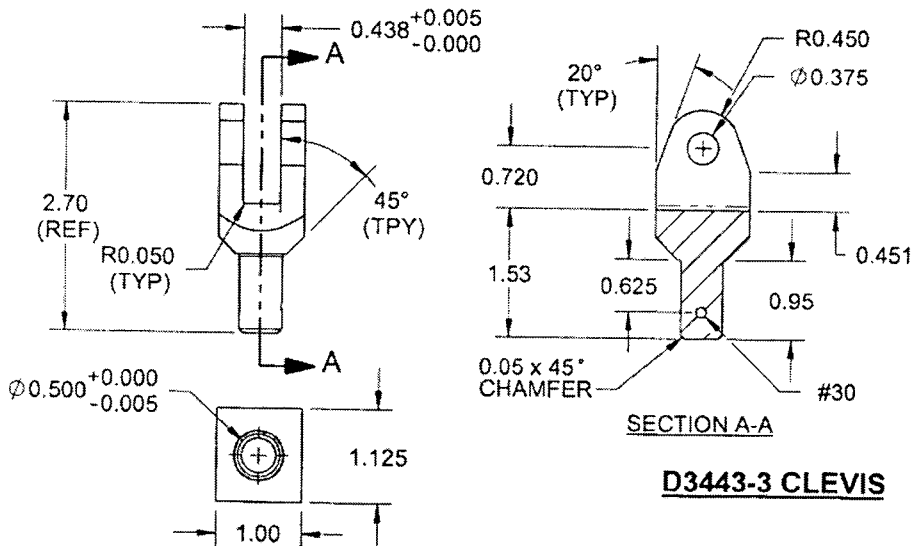
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY		SHEET 2 OF 3
			SCALE 1:2

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

D3443-1 LUG**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

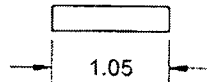
- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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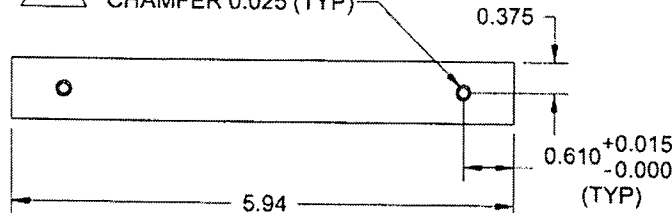
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY		SHEET 3 OF 3 SCALE 1:2

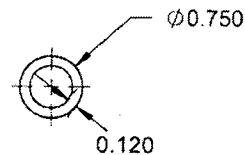
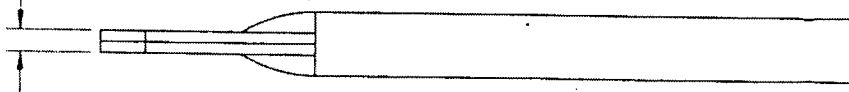
 $\phi 0.210^{+0.005}_{-0.010}$ **D3443-9 PIN****D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

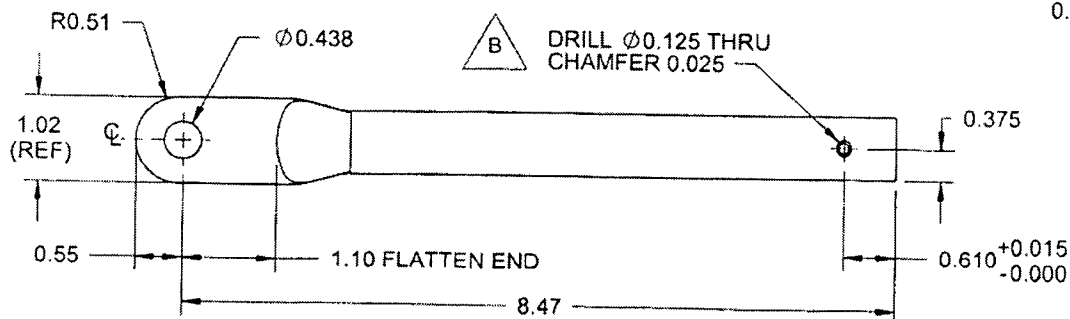
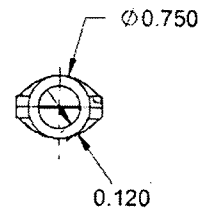
DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)

RELEASED

05.12.05

**D3443-5 TUBING** $0.260^{+0.000}_{-0.030}$ 

46560

**D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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